

Date: Monday, 18/08/2008 4:04:01 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SQUARE SPACER
Job Number :	41351		
Estimate Number :	11300		
P.O. Number :		Part Number :	D34473
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3447 REV A
First Issue :	18/08/2008	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	18/09/2008
Written By :		Qty:	20
Checked & Approved By :	<u>JL 08.8.18</u>	Um:	Each
Comment :	Est. A05.10.19 New issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00 x 1.00 x .125w
Comment: Qty.: 0.1860 f(s)/Unit Total : 3.7191 f(s) 6061T6 SQ TUBE 1.00X.125 Material: 6061-T6 Square Tubing 1.000 x 1.000" x 0.125" wall (M6061T6TS1.000W.125) Identify for D3447-3 Batch: <u>M 109053</u>		
		SAD 08/09/26 20
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Cut to length: 2.000" long as per Dwg D3447 Rev: <u>A</u> Deburr Identify as D3447-3		
		SAD 08/09/26 30
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
		SAD 08/09/26 20
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
		M-1 08/09/27 20X
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 Mask inside wall		
		M-1 08/09/27 20X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:04:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE SPACER

Job Number: 41351

Part Number: D34473

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320 °F
11:30

MF 08/01/27
(20X)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-29

(20X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

HL 8/9/29 (19)

PH

8.0

QC21

FINAL INSPECTION W/O RELEASE



08/10/02

Comment: FINAL INSPECTION W/O RELEASE

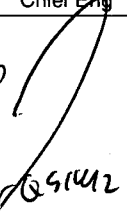


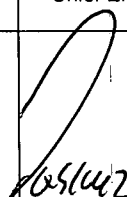

Job Completion



MF 08-10-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: 123447-3 PAR #: N/A Fault Category: Prod stores NCR: Yes No DQA: D Date: 08/09/30
PB 4302 67-43001-01
Resolution: _____ Disposition: _____ QA: N/C Closed: D Date: 08/10/30

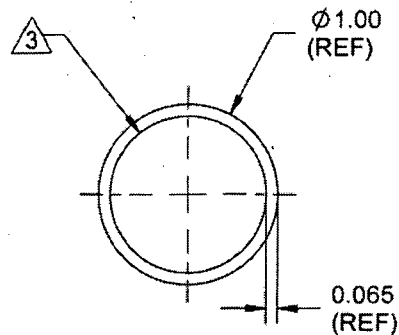
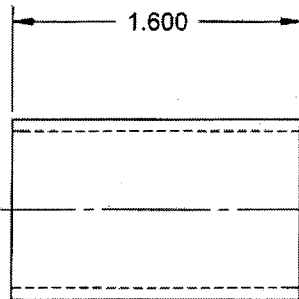
NCR: <u>41351</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/13/30	7.0	one part lost lost between Powder coating to show. RC no one knows what happened.		mark one part lost lost no replace qty	 08/10/01	 08/10/01	 08/10/01	 08/09/30

NOTE: Date & initial all entries

DART

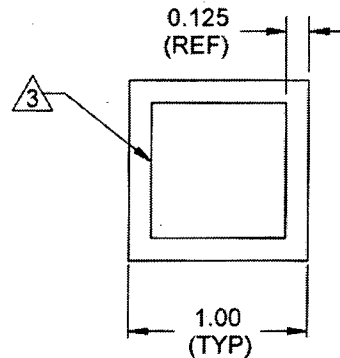
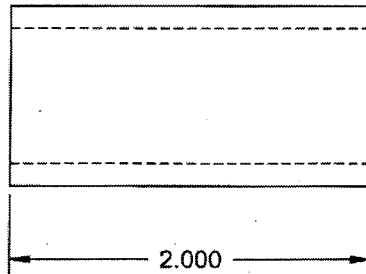
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
05/08/18



D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)



D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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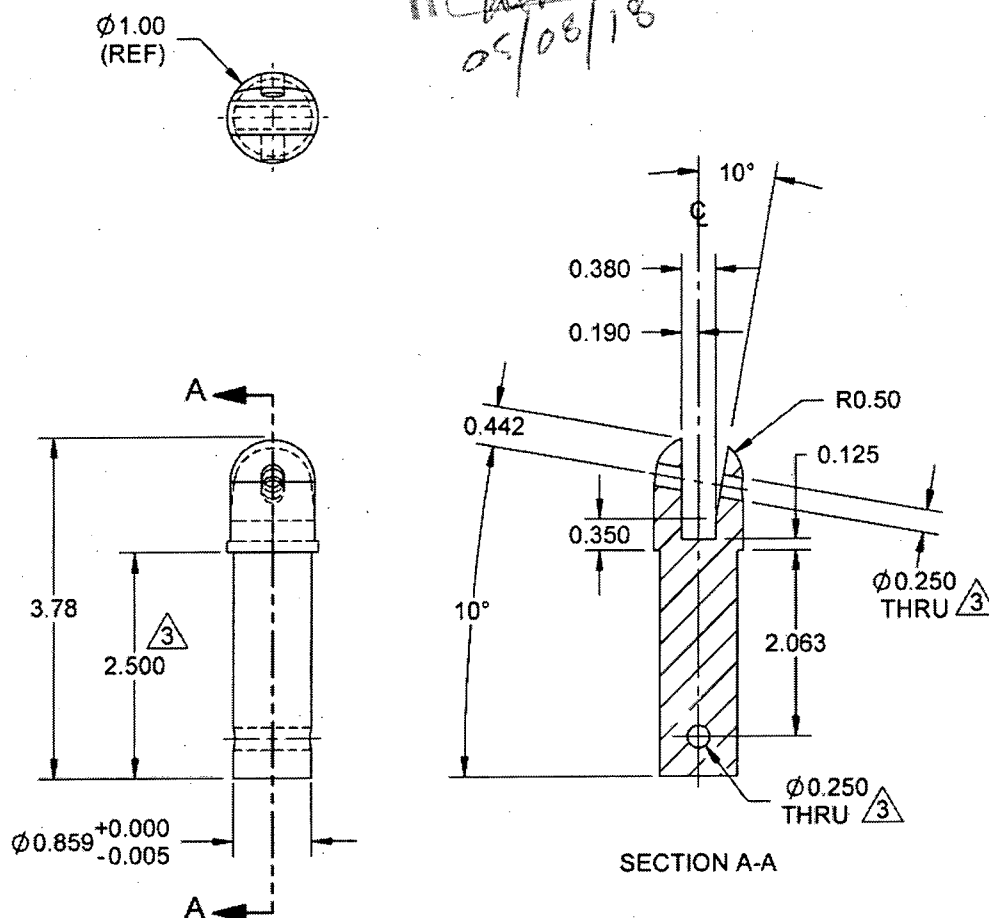
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
[Signature]
05/08/18



D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

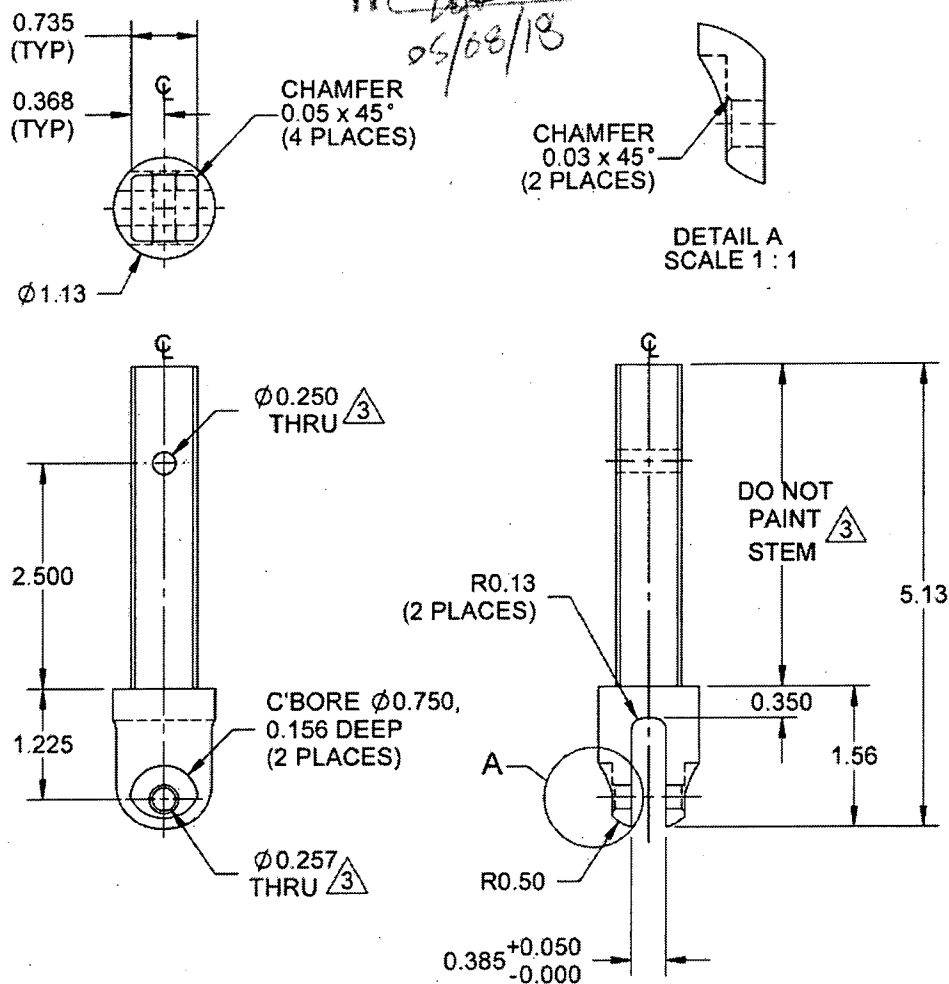
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



D3447-7 CLEVIS

SUPERCEDES PREMIER P/N B67-43001-145/-345

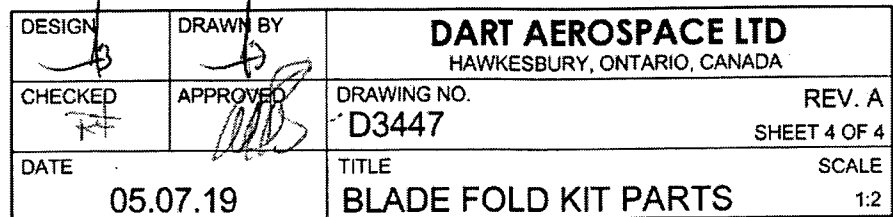
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

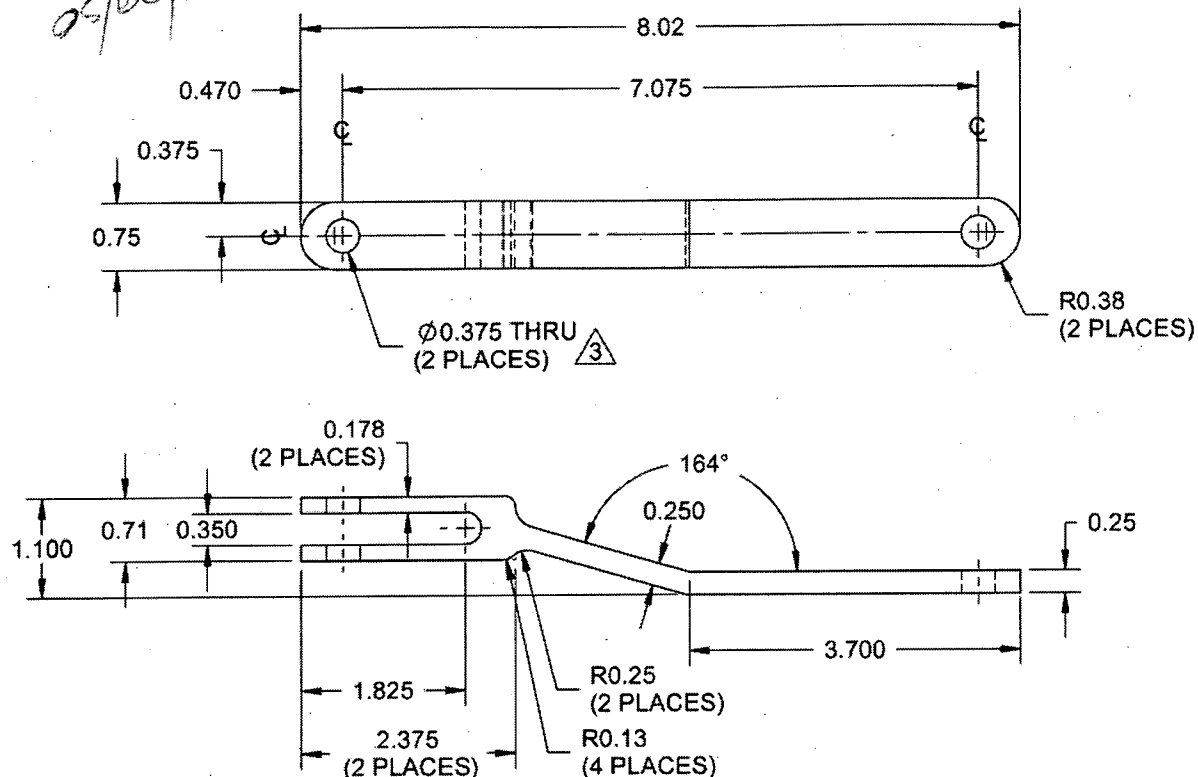
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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